

# Work Order ID 72196

Wednesday, July 20, 2011 7:48:48 AM

Page 1

Item ID: D4153-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Joggle Bracket

Start Date: 7/19/2011 Start Qty: 12.00

Required Date: 7/26/2011 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: 11

Date: 11-07-20 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4153

A U/R

per attached email

110

0.00



Waterjet

FLOW CNC Waterjet

Memo

CUT AS DWG

DWG REV: 1

PROG REV: 1

DEBURR

0.00

11/07/27

12

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

11/07/27

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 72196**

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Page 2

Item ID: D4153-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Joggle Bracket

Start Date: 7/19/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				W	11	07	28 (12)
140  Brake NC Brake NC	Form as per dwg  Memo	0.00  0.00		SB 11/09/06		(12)			
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		S 11/09/06		(12)			

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**Work Order ID 72196**

Wednesday, July 20, 2011 7:48:48 AM



Page 3

Item ID: D4153-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Joggle Bracket

Start Date: 7/19/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



Packaging

Identify as per dwg & Stock Location ST 13A

0.00

Memo

0.00

Packaging

(12A) SP 11-09-06

170



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/9/6

MF 11-09-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 20, 2011 7:48:56 AM

Page 1

Work Order ID: 72196

Parent Item: D4153-1

Parent Item Name: Joggle Bracket



Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.10.06 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No			110	sf	237.6550	0.875	11.05263			



304/316 .050 Sheet



Location	Loc Qty	Loc Code
MAT020	85.655	
113062	13.655	
116135	3	
116979	69	
MAT021	152	
118217	152	

8.0 ~~11/07/27~~

4.0 ~~11/07/28~~

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_



Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



## FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	10.10.25	New Issue	KJ 	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

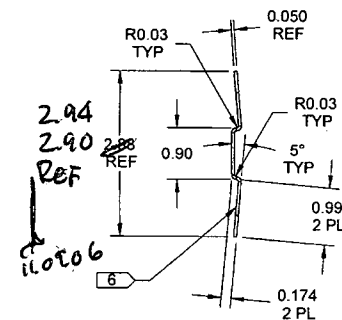
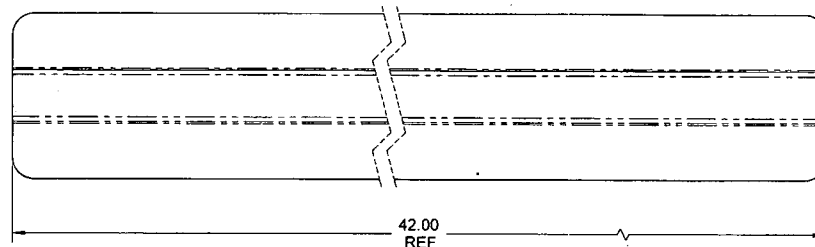
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 72194 1107-20



**D4153-1 JOGGLE BRACKET**  
(MAKE FROM D4153-1F FLAT PATTERN)

~~UNDER REVIEW~~

RELEASED  
2010-09-23  
*aw*

- NOTES:  
1) MATERIAL: MAKE FROM D4153-1F FLAT PATTERN  
2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: PER QSI 044 6.1, ON THE UNDERSIDE OF THE PART AS INDICATED  
7) WEIGHT: 1.82 lbs

A		NEW ISSUE		RF	10.09.16
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA			
DRAWN	RF				
CHECKED	<i>MP</i>	DRAWING NO. <b>D4153</b>		REV. A	
MFG. APPR.	<i>DS</i>			SHEET 1 OF 2	
APPROVED	<i>MP</i>	TITLE <b>JOGGLE BRACKET</b>		SCALE	
DE APPR.	<i>MP</i>			NTS	
DATE	10.09.16	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

72194

R0.38  
TYP

BEND LINE

3.00  
2.00  
1.91  
1.09  
1.00  
0.00

0.050  
REF

42.00

**D4153-1F FLAT PATTERN**

~~UNDER REVIEW~~

10/11/09

RELEASED  
2010-09-23

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 18 GAUGE (0.050 THICK)  
PER MIL-S-5059  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
PER DART SPEC M304S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.82 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	AS	D4153	SHEET 2 OF 2
APPROVED	AP	TITLE	SCALE
DE APPR.	TH	JOGGLE BRACKET	NTS
DATE	10.09.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

## Linda Lacelle

---

**From:** David Shepherd <dshepherd@dartaero.com>  
**Sent:** July 20, 2011 11:11 AM  
**To:** 'Linda Lacelle'; 'Robert Fuentes'  
**Cc:** 'Mike Petsche'  
**Subject:** RE: D4153-1

Linda,

As discussed, we are going to be sending out an UNDER REVIEW form that clarifies what to do with some of the AW139 parts. D4153-1 Rev A are acceptable to ship, but there is a change coming.

David

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**From:** Linda Lacelle [mailto:llacelle@dartaero.com]  
**Sent:** July-20-11 5:22 AM  
**To:** Robert Fuentes  
**Cc:** dshepherd@dartaero.com; 'Mike Petsche'  
**Subject:** D4153-1  
**Importance:** High

Is still in Prelim, but all the 139's are released...??? Need to ship next week..

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd  
Hawkesbury, ON  
Phone: 613 632 9577  
Fax: 613 632 1053  
Cell: 613 676 1655